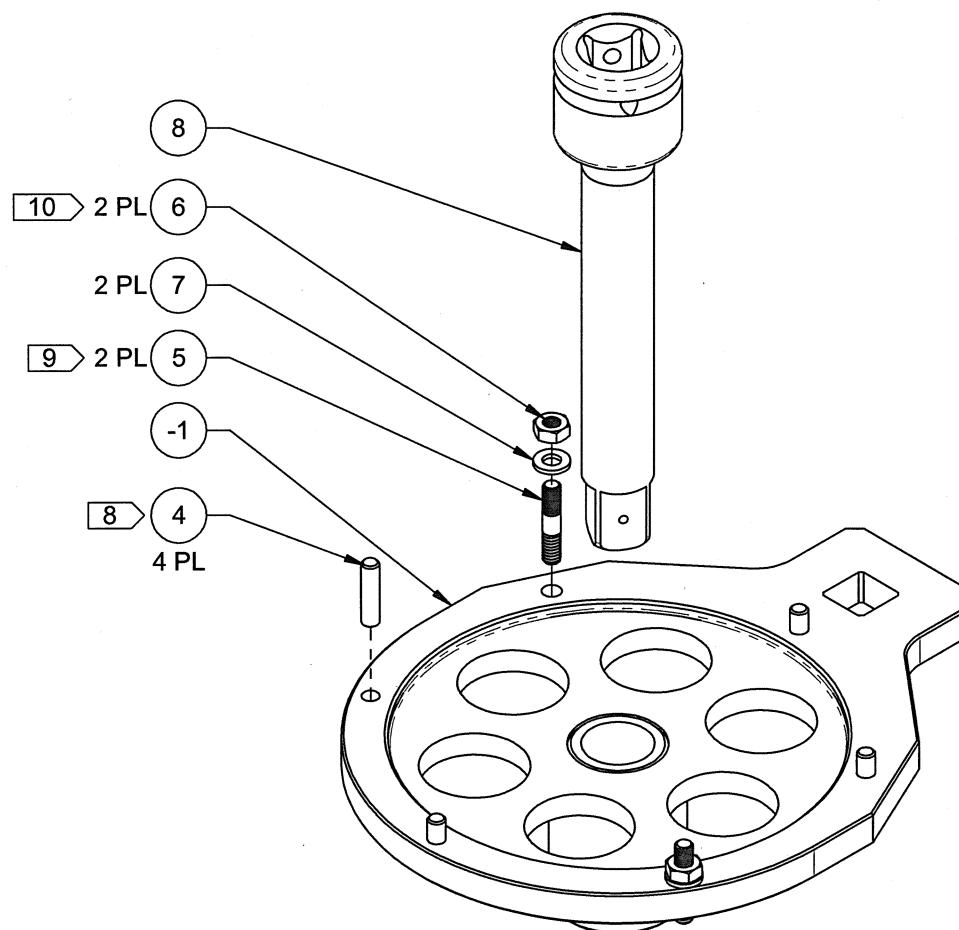
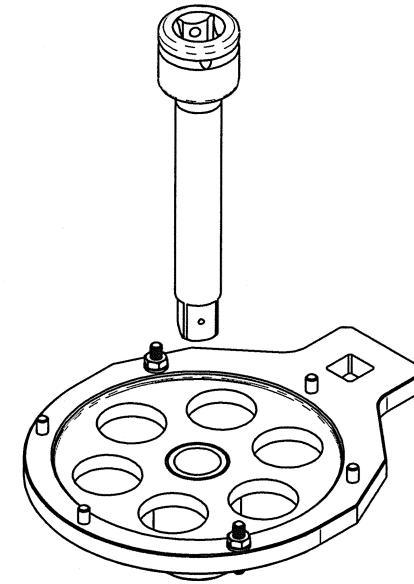
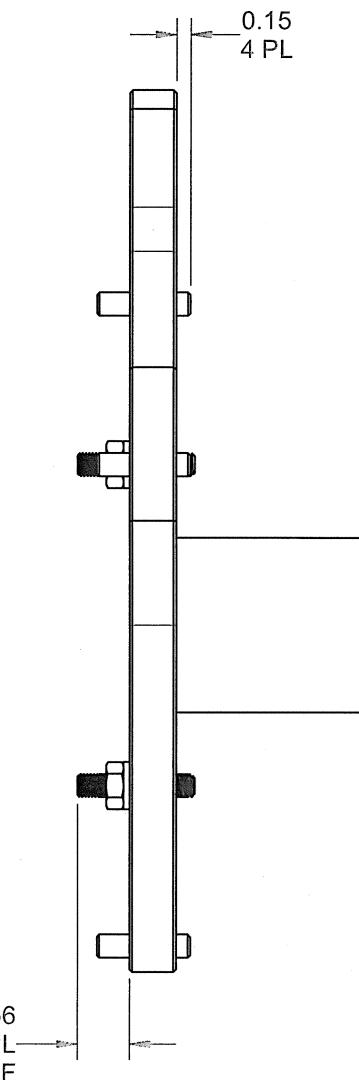
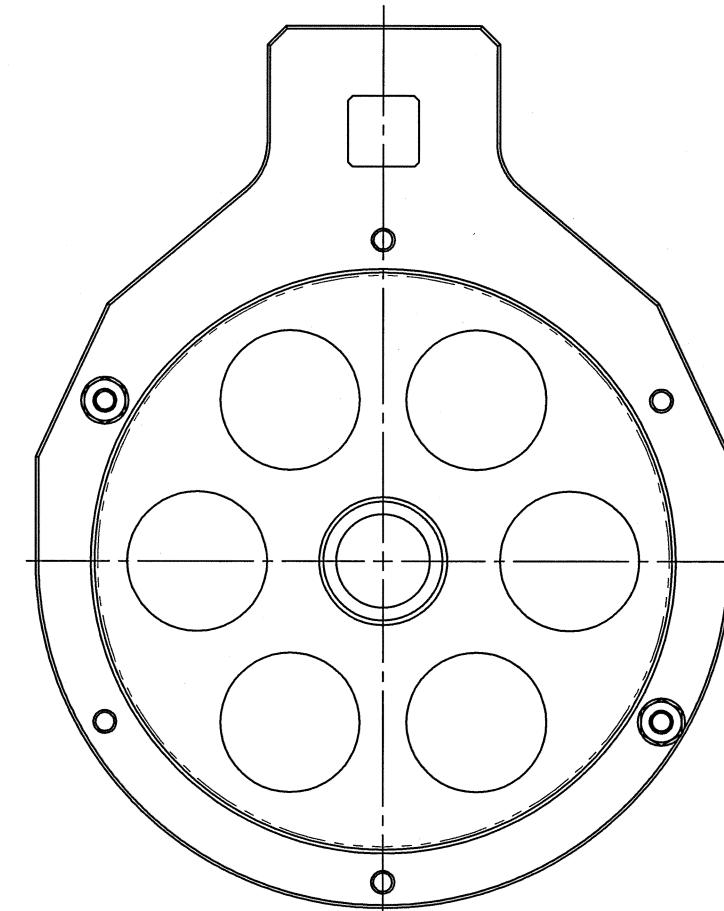


ITEM #	QTY	PART #	PART TITLE
-1	1	RB T103063-1	Fixture Assembly
4	4	McMaster#98381A330 OR EQUIV	BLACK OXIDE STEEL DOWEL PIN 1/4" DIA. X 1" LG.
5	2	AN125964	CAD PLATED STEEL STUD 1/4" X 1-1/4" LG. X 1/2" THREAD LENGTH
6	2	AN315-4R	CAD PLATED STEEL HEX NUT 1/4"-28 X 0.172-0.204 THK.
7	2	NAS1149F0463P	STEEL WASHER 0.265" ID. X 0.500" OD. X 0.063" THK.
8	1	SNAP-ON #L62 OR EQUIV	CHROME PLATED STEEL SOCKET EXTENSION 3/4" DRIVE X 8" LG.



RB T103063 TOOL SET HOLDING

11



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 3 WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON COARSE THREADS OF ITEM 4 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
- 10) INSTALL ITEM 6 HAND TIGHT
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

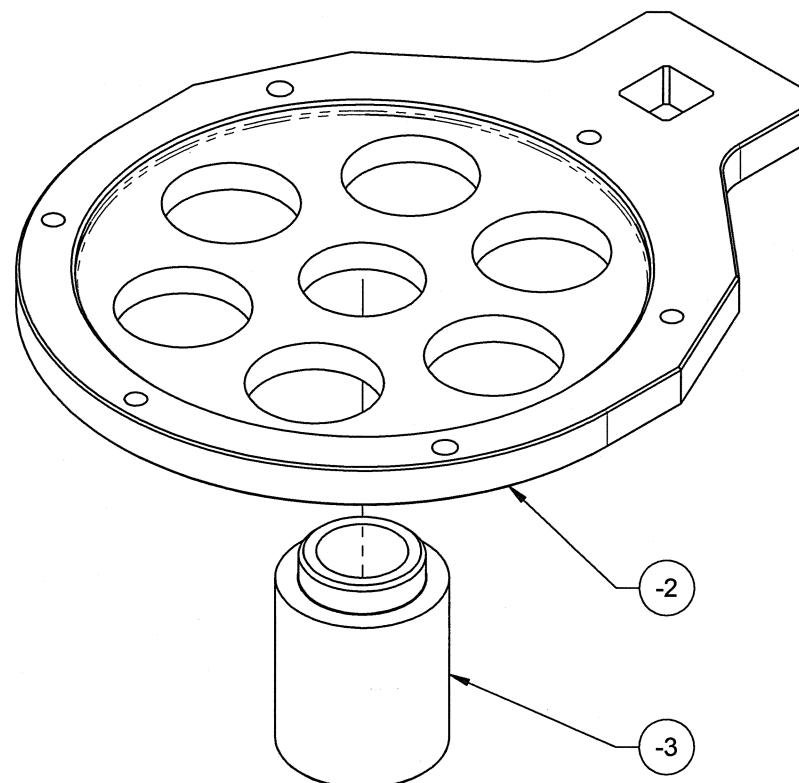
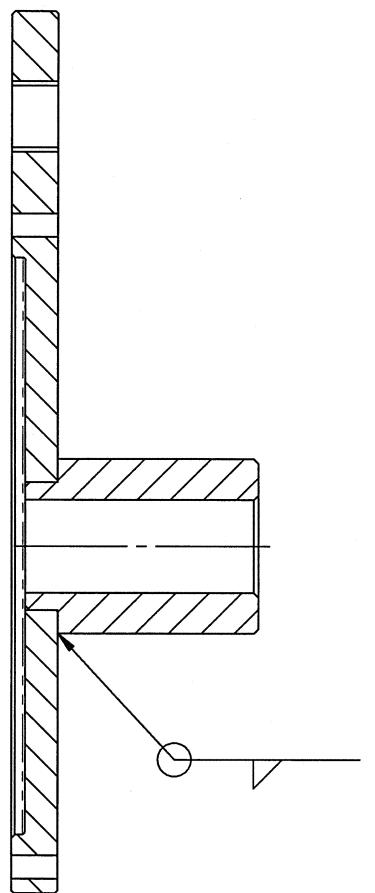
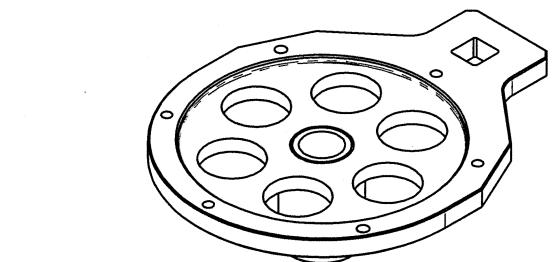
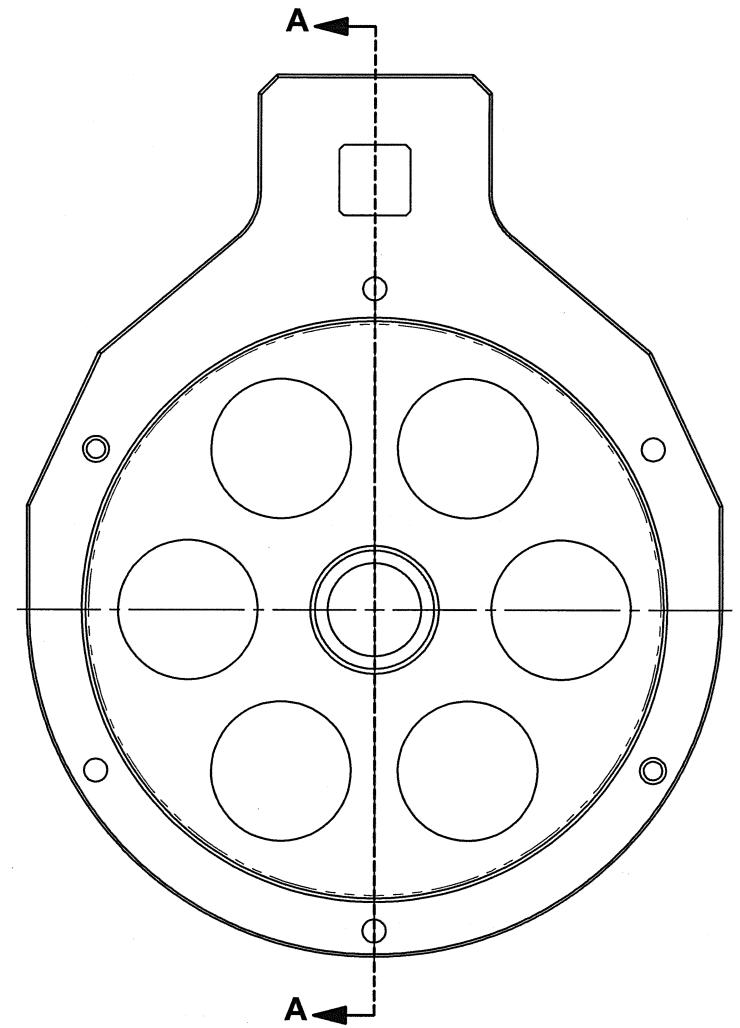
A	NEW ISSUE	19-784	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	FK	SHEET 1 OF 4	
APPROVED	<i>WJ</i>	SCALE	
DATE 2019-06-28		NTS	
TOOL PART #			
RB T103063			
TITLE			
SET HOLDING			

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ITEM #	QTY	PART #	PART TITLE
-2	1	RB T103063-2	FIXTURE
-3	1	RB T103063-3	BAR

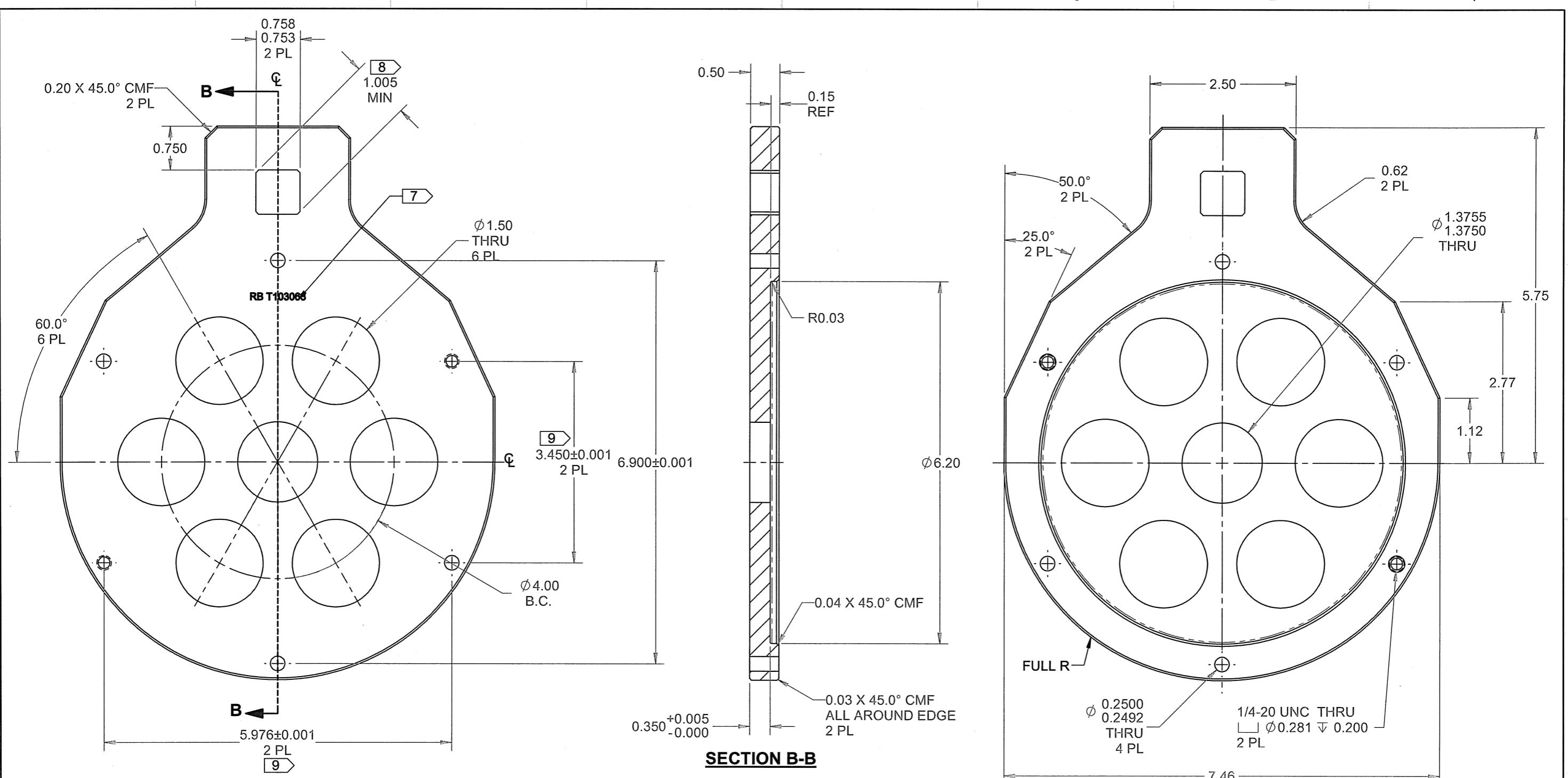
D

**RB T103063-1 FIXTURE ASSEMBLY****SECTION A-A****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: 36-40 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RB T103063	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
		SET HOLDING	NTS
DATE 2019-06-28			

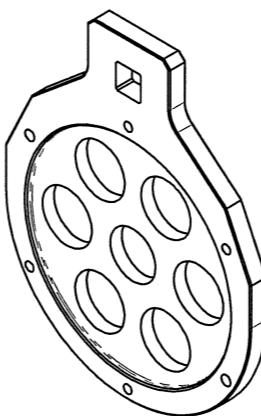
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RB T103063-2 FIXTURE

NOTES:

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB T103063", AS SHOWN
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY
- 9) SYMMETRIC TOLERANCE OF ± 0.001 ONLY APPLICABLE FOR DOWEL PIN HOLES OF $\phi 0.2500/0.2492$



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RB T103063 REV. A	
APPROVED	VIP	TITLE SHEET 3 OF 4	
DATE	2019-06-28	SCALE	NTS
SET HOLDING			

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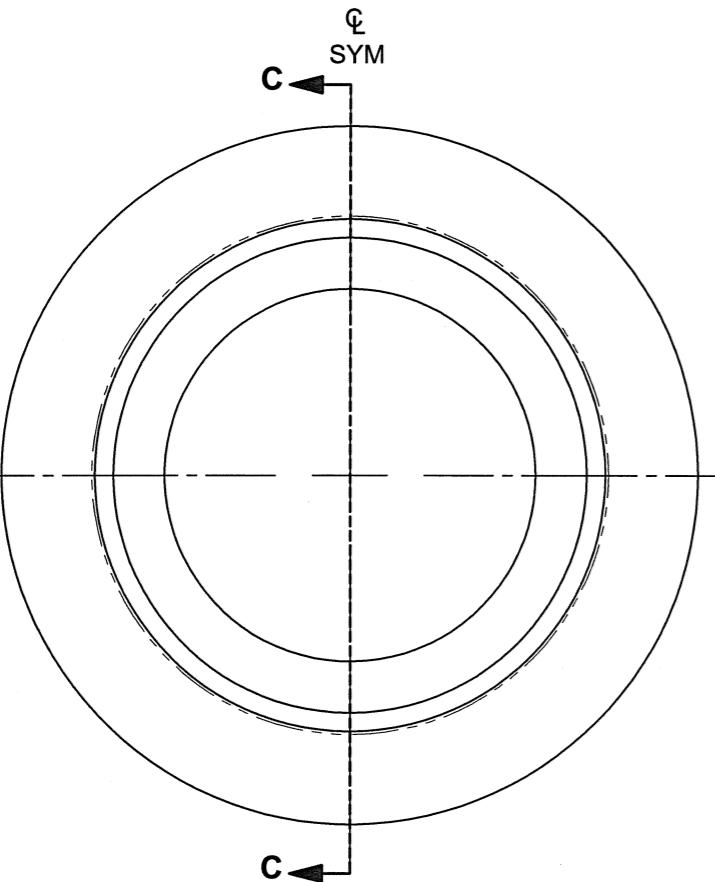
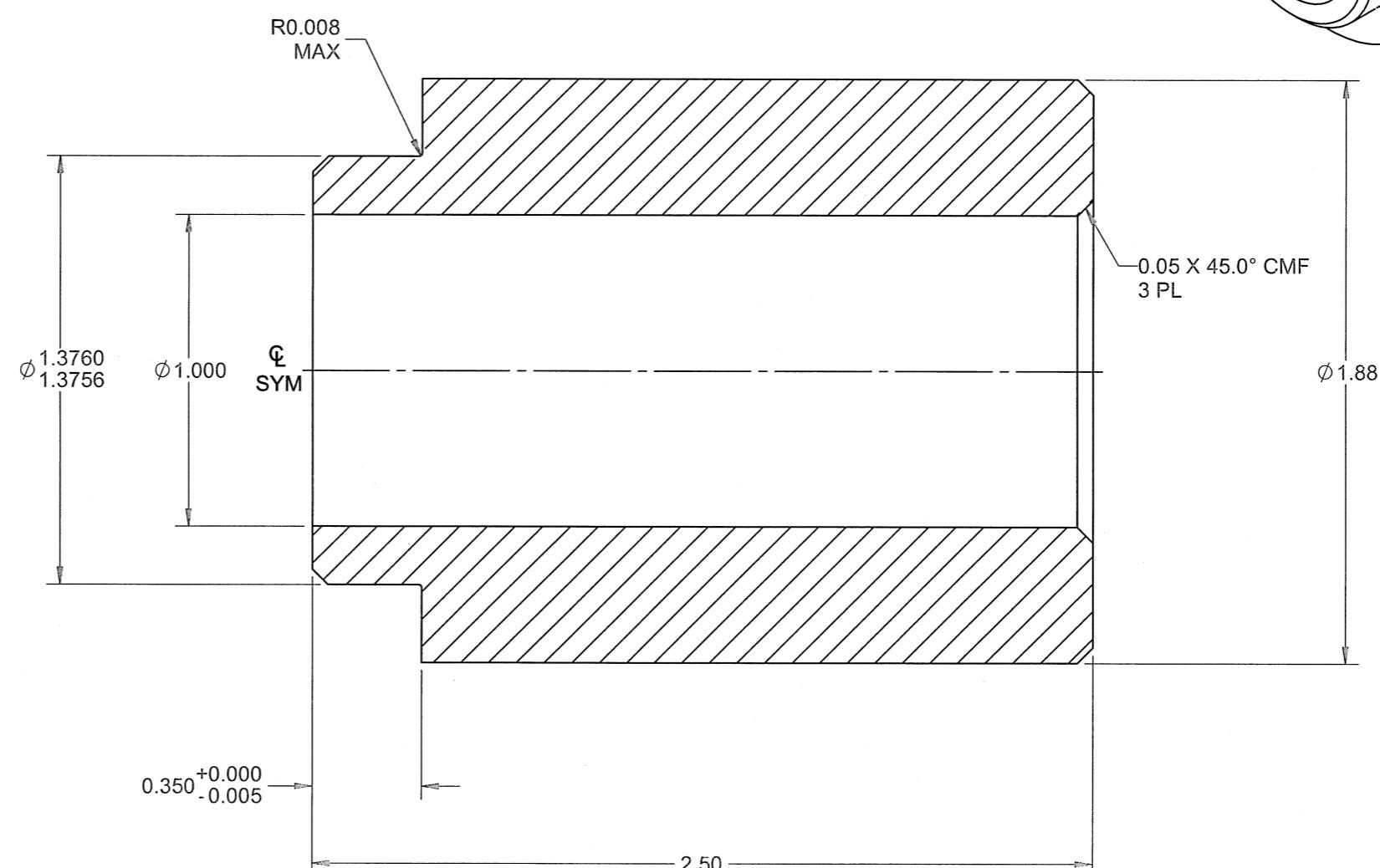
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**RB T103063-3 BAR****NOTES:**

- 1) MATERIAL: 4140
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	KPT	TOOL PART #	REV. A
APPROVED	FK	RB T103063	SHEET 4 OF 4
		TITLE	
		SET HOLDING	
DATE 2019-06-28		SCALE NTS	

WJ

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